

Date: Monday, 05/05/2008 4:12:26 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM
 Job Number : 39059
 Estimate Number : 10346
 P.O. Number :
 This Issue : 05/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2596
 Drawing Number : D2596 REV D
 Project Number : N/A
 Drawing Revision : D
 First Issue : / / Type : SKIDTUBES Material :
 Due Date : 10/05/2008 Qty: 4 Um: Each
 Previous Run : 38951
 Written By :
 Checked & Approved By : JLD 08-5-05
 Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D
 M
 Est Rev:E 07-07-09 Incorporated DEO 9183 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Extr'n -I" Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Extrusion "I" Beam Web 4"

Pick;

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | D2500-3-100 | Extrusion | B 33940 |

(4) M 8-5-7

2.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

M 8-5-7 (4)

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

M 8-5-7

(4)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/05/07 (4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 39059

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G.

④ W 8-5-7

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/0978

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-08.

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

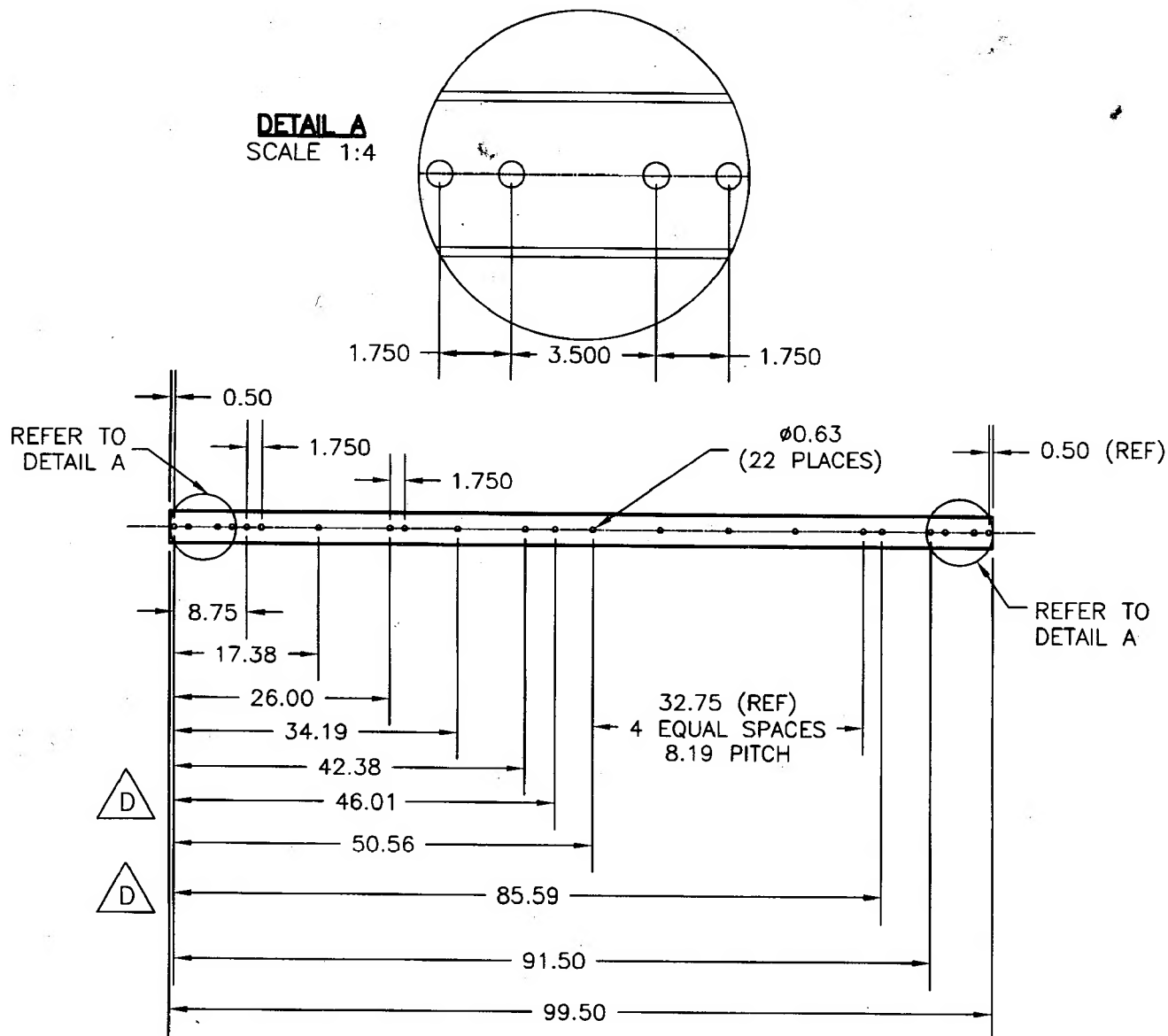
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | | | | | | |
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NOTE: Date & initial all entries

DART

RELEASED
07 Dec 68

| | | | |
|------------------|----------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
| CHECKED PA | APPROVED GH | DRAWING NO. D2596 | REV. 0 |
| DATE 07.04.17 | | TITLE 205 WEB | SHEET 1 OF 1 |
| A | 96.09.16 | NEW ISSUE | SCALE |
| B | 97.07.23 | Ø0.63 HOLE WAS Ø0.56 | 1:20 |
| C | 98.09.14 | INCORPORATED DEO 9097 | |
| D | 07.04.17 | INCORPORATED DEO 9183 | |



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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